

Work Order ID 68627

Monday, April 18, 2011 4:34:55 PM

Page 1

Item ID: D3025-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Beam

Start Date: 4/19/2011

Start Qty: 3.00

Required Date: 4/26/2011

Req'd Qty: 3.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 11-04-18

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3025	Rev A1

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

2024 ASD

1-Cut as per Dwg  
Dwg Rev: A1  
Prog Rev: A1  
2-Deburr if necessary

11-4-25

6

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

11-4-25

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

Subtotal

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68627**

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Page 2

Item ID: D3025-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Beam

Start Date: 4/19/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 4/26/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Brake NC

Bend as per dwg

NC BRAKE

0.00

Memo

0.00

SB 11/04/26

6

Brake NC

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

6 BR 11-4-27

Hand Finishing

150



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

6 Q 11/04/27

Quality Control

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Page 3

Item ID: D3025-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Beam

Start Date: 4/19/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 4/26/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location: 177

0.00



Packaging

Memo

0.00

Packaging

11/4/27 (6)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/27 MF  
11-04-27

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, April 18, 2011 4:34:50 PM

Page 1

Work Order ID: 68627



Parent Item: D3025-1



Parent Item Name: Beam


Start Date: 4/19/2011

Required Date: 4/26/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP C001.10.26 Added Bending as per Drawing. SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050  2024-T3 .050 sheet		Purchased	No			100	sf	23.6488	0.89	2.810526		S, B11-4-25	

Location

MAT22

114968

Loc Qty

23.648842

23.648842

Loc Code

114968

6

W/O:		WORK ORDER CHANGES					
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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

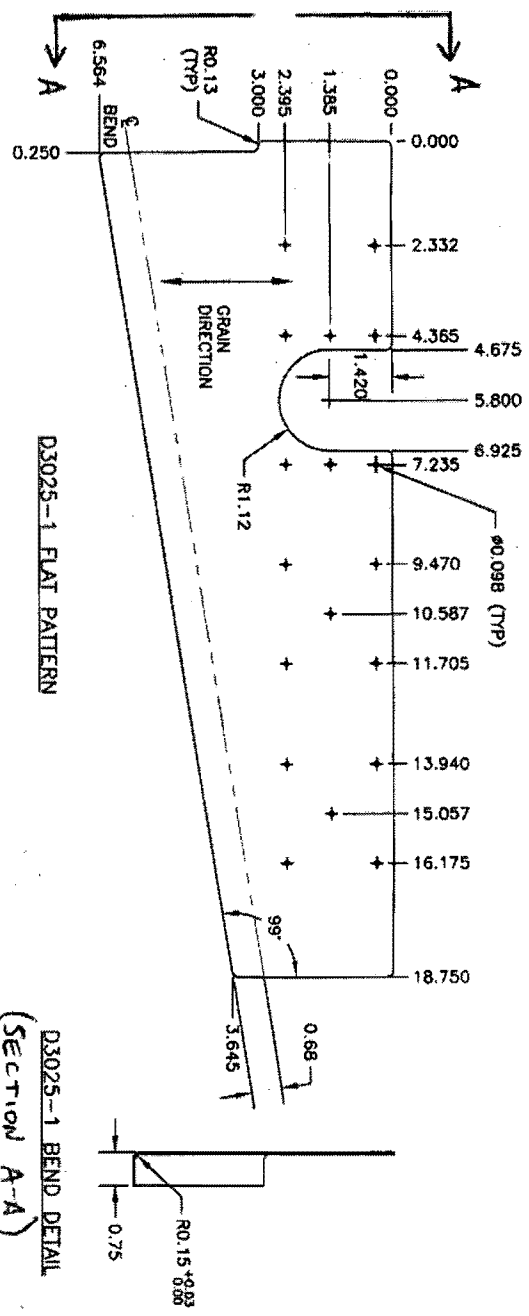
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

RELEASED  
01.05.30

# 68627



- NOTES:
- 1) BREAK ALL UNMARKED SHARP CORNER 0.010 TO 0.020
  - 2) MATERIAL: 2024-T3 (00-A-250/4) 0.050" THICK
  - 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART AEROSPACE LTD		DRAWN BY KT		DESIGN KT	
HAWKESBURY, ONTARIO, CANADA		APPROVED #		CHECKED #	
D3025		TITLE BEAM		DATE 01.05.18	
SHEET 1 OF 1		NEW ISSUE		A	
REV. A		ADD SECTION A-A		A1	
SCALE 1:4		01.10.19		# CP	

**DART**



W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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